

5/37

DART AEROSPACE LTD	Work Order:	24248
Description: Angle extrusion	Part Number:	D6207
Drawing: D6207 Rev. A	Qty:	40

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	<i>[Signature]</i>	05.09.14	40
2	PURCHASING	Issue P/O: <u>7008632</u> a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125" b) Material: 6061-T6/T6511 (QQ-A-200/8) c) Minimum ultimate tensile strenght = 38 ksi d) Minimum yield tensile strenght = 35 ksi	<i>[Signature]</i>	05-09-14	40
3	RECEIVING	Inspect for transit damage Ensure certification are attached	<i>[Signature]</i>	05/09/20	40
4	QC	Inspect level 6 Check certification to Dwg D6203 for compliance Check hardness with Webster tester	<i>[Signature]</i>	05-09-21	40
5	RECEIVING	Receive & Identify	<i>[Signature]</i>	05/09/20	40
6	EXPEDITING	Close W/O Inspect level 21 Cost / part <u>1.25</u> <i>SUC 05/09/22</i> <u>(40)</u>	<i>[Signature]</i>	05/09/22	40

Rev	Date	Change	Revised By	Approved
A	02.03.15	New Issue	NG	<i>[Signature]</i> 02-03-15

RELEASED

02/03/15 *[Signature]*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DS Date: 05/05/22

NOTE: Date & initial all entries

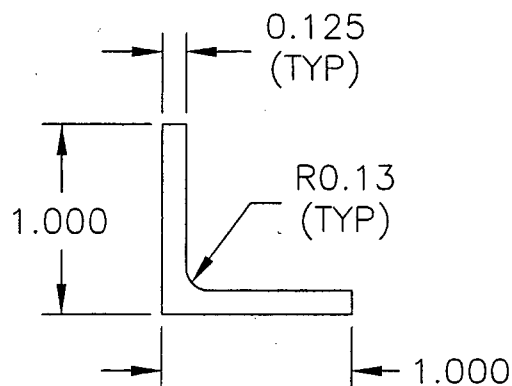
QA: N/C Closed: _____ Date: _____



DESIGN [Signature]	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING



D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT 1
VARIATION

WORK ORDER

NO. 24248

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 13, 2005
03:34 pm

Work Order No	: 0024248	Department Code:	
Project Name	: D6207	Burden Flags	: NNNNNNNN
Project For	: WK537	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6207	Invoice Number	:
Description	: Angle Extrusion 1x1x.125	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 40	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 09-13-05		
Est Finish Date	: 09-14-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

6061 Chemical Composition (%)														Tensile Strength		Yield Strength		Elongation		
Product Code	Die No.	Specification	Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Pb	Bi	Zr	Al	Min ¹	Max ²	Min ¹	Max ²	%
				0.10-0.80	0.80-1.20	0.70 max.	0.15-0.40	0.15 max.	0.30 max.	0.04-0.35	0.15 max.	--	--	--	Rem.	265	38	245	38	8
3308-1025	8079	ANG.E3/4X3/411/BRF	40088	0.655	1.029	0.129	0.228	0.010	0.008	0.145	0.008				Rem.	302	43.0	268	39.0	13.5
3308-1075	6009-318	ANG.E1X1X1/BRF	40093	0.688	1.029	0.129	0.228	0.010	0.008	0.145	0.008				Rem.	327	47.0	276	40.0	12.1

Koro Klu Aluminium Group hereby certifies that metal shipped under the above mentioned PO No, Contract No, and Container No has been inspected and tested, and found in conformance with the applicable specifications forming a part of the description set forth in Main Klu Sales Contract.

Prepared By:

Waley

Checked By:



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09/19/2005 12:00

450-377-5595

ACIER CAMP

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